

Date: Wednesday, 12/20/2006 11:58:59 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : JET
 Job Number : 29990
 Estimate Number : 10583
 P.O. Number : N/A Part Number : D2003077
 This Issue : 12/20/2006 S.O. No. : N/A Drawing Number : UNDER REVIEW CB
 Prsht Rev. : NC Project Number : N/A 06.12.20
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : 29928A Material : N/A
 Due Date : 1/15/2007 Qty: 11 Um: Each
 Written By :
 Checked & Approved By : 06 12.20
 Comment : Est: A 04.05.17 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T0375W035 6061-T6 Tube .375 x.035W



Comment: Qty.: 1.0625 f(s)/Unit Total : 11.6875 f(s)

6061-T6 Tube .375 x.035W

Material: 6061-T6 tubing 0.375OD x 0.035" wall

(M6061T6T0.375W.035)

Batch: m17931

8.5(f)

MF 07-01-08

m19051 x 3.1875(f)

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Cut (2) D2003-077 blanks per (1) DSI 9051 Kit

2- Cut blanks: 6.250" long as per template D2003-077

3- Form, drill & as per template D2003-077

Identify for D2003-077

MF 07-01-09

3.0 516IN200 Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)

Set Screw

Pick:

Qty Part Number Description Batch

1 2 5/16"-18 NC -200

Set Screw

m19473

MF 07-01-09

4.0 AN8186D Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

1 2 AN818-6D

Nut

m17651

MF 07-01-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-01-08	2.0	Remove Flare. And put at step 6.0 at Assembly, After putting on the sleeve. Perm. Change	MF.	07-01-09	11	07-01-08 Q51042	07-01-08	
07-01-09	6.0	Applied lockite 262 threadlocker. #B m102963 on each screw. ADD TO step 6.0 perm-change	MF.	07-01-09	11	07-01-15 Q51042	07-01-15	

Part No: 82003-077 PAR #: _____ Fault Category: Drilling Engineering (Coordinator) NCR: Yes No DQA: Q Date: 07/01/31
QA: N/C Closed: _____ Date: _____

NCR: <u>29990</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-08	2.0	w/o instructions were wrong. Flare was made before the hardware was picked, and the sleeve was installed.	Q51042	grind off the flare as necessary to install m320819-6D sleeve. Then flare.	MF. 07-01-09	07-01-15	Q51042	07-01-08

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:58:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JET

Job Number: 29990

Part Number: D2003077

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS208196D

Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)

Sleeve

Pick:

Qty

Part Number

Description

Batch

2

MS20819-6D

Sleeve

M17654

MF. 07-01-09.

~~M17654~~ ~~M17654~~ ~~M17654~~

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2003

Identify as D2003-077

MF. 07-01-09

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-15

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/01/30 (11)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/31

Job Completion



U 07-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>JE</i>	DRAWN BY <i>JE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JE</i>	APPROVED <i>JE</i>	DRAWING NO. D2003	REV. B SHEET 1 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	
A	90.04.09	NEW ISSUE	
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

RELEASED
44.06.08 KE

NOTE: FLAT LENGTHS MAY BE
INCORRECT. BEND TO BENT
TOOL. REPORT TO ENGINEERING

UNDER REVIEW

CC.08.21 CB

CB
some Flat 06.12.13
lengths wrong

SHOP COPY
RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER 29990
NO. ~~06.12.13~~

P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/5/7}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2003	REV. 8 SHEET 2 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	

RELEASED
49.06.09 KE

UNDER REVIEW CB
06.12.13

06.08.21 CB

Some Flat lengths
and wrong

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~29990~~ 29990

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (VW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

